

Work Order ID 60587

Thursday, July 15, 2010 10:18:11 AM



Page 1

Item ID: D205-708-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Adjustable Engine Mount

Start Date: 7/15/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: 

Date: 10-7-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

B80701

Rev C

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D205-708-011, CHG001

8/10/09/10

HJ for BG 10-9-01
(2)

110

0.00



Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: 12260 for:

6 /	D3284-001 /	(B80702-1)	Sleeve
2 /	D3284-003 /	(B80703-1)	Stud
4 /	D3284-005 /	(B80704-1)	Stud
6 /	D3284-007 /	(B80705-1)	Stud
6 /	NAS509-12 /	Nut	
6 /	NAS509L12 /	NutStud	

To be assembled as per Dwg B80701 Rev. C
Possible Supplier: Northern Aero
Certificate of Conformity is required

8/10/09/131

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D205-708-011

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Setup Start

Revision ID:

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Item Name: Adjustable Engine Mount

Start Date: 7/15/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

150

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D205-708-011

Location: 51PPP Rev: 2

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

8210/9/13 210/09/14 MF
10-9-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, July 15, 2010 10:18:16 AM

Page 1

Work Order ID: 60587

Parent Item: D205-708-011

Parent Item Name: Adjustable Engine Mount




Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP C 06.01.31 Added MS206136C12 ☐JLM/AP☐
IPP Rev:D 07-12-12 as per ECN 1074 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3284-001  Sleeve		Manufactured	No			140	Each	2.0000	6	12			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST049				2					
					59910			2					
D3284-003  Stud		Manufactured	No			140	Each	6.0000	2	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST049				6					
					32724			4					
					35656			2					
D3284-005  Stud		Manufactured	No			140	Each	6.0000	4	8			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST049				6					
					39942			2					
					43645			4					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 15, 2010 10:18:16 AM

Page 2

Work Order ID: 60587



Parent Item: D205-708-011



Parent Item Name: Adjustable Engine Mount

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 2.00

Required Qty: 2.00

D3284-007

Manufactured No

140 Each

13.0000

6

12



Stud



B60587 (80105) L

Location

Loc Qty

Loc Code

ST

6

59048

6

ST049

7

55427

1

59048

6

D3284-009

Manufactured No

140 Each

2.0000

6

12



Bearing



B61236 10/1/25
B61802 20 10/1/25

Location

Loc Qty

Loc Code

ST049

2

60043

2

D3284-011

Manufactured No

140 Each

18.0000

1

2



Bearing



10/1/25

Location

Loc Qty

Loc Code

ST046

17

60004

17

ST50

1

58724

1

MS20613-6C12

Purchased No

140 Each

105.0000

2

4



RIVET



10/1/25 (20)

Location

Loc Qty

Loc Code

ST322

105

100089

6

105433

99

Thursday, July 15, 2010 10:18:16 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 3

Work Order ID: 60587

Parent Item: D205-708-011

Parent Item Name: Adjustable Engine Mount

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 2.00

Required Qty: 2.00

MS20613-6C16 Purchased No
Rivet

140 Each 26.0000 8

16

10/9/12 sl

Location

Loc Qty

Loc Code

ST323

26

114035

26

10

MS20613-6C18 Purchased No
Rivet

140 Each 47.0000 4

8

10/9/12 sl

Location

Loc Qty

Loc Code

ST323

47

19513

47

8

MS20613-6C19 Purchased No
Rivet

140 Each 0.0000 12

24

11/29/11 sl

NAS509-12 Purchased No
Nut

140 Each 36.0000 6

12

B60587

Location

Loc Qty

Loc Code

ST280

36

15057

36

NAS509L12 Purchased No
Nut

140 Each 40.0000 6

12

B60587

Location

Loc Qty

Loc Code

ST280

40

102296

31

15062

9

Thursday, July 15, 2010 10:18:16 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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SPECIFICATION CONTROL DRAWING

DART P/N	SPECIFICATION
D3284-001 SLEEVE	ACS P/N B80702-1 PER ACS DWG B80702 REV. A
D3284-003 STUD	ACS P/N B80703-1 PER ACS DWG B80703 REV. A
D3284-005 STUD	ACS P/N B80704-1 PER ACS DWG B80704 REV. A
D3284-007 STUD	ACS P/N B80705-1 PER ACS DWG B80705 REV. B
D3284-009 BEARING	BHT P/N 47-140-252-5
D3284-011 BEARING	BHT P/N 205-060-101-001
D3284-021 TUBE ASSY	204-060-158-001 MODIFIED PER IIN-D205-708
D3284-023 BIPOD ASSY	204-060-155-001 MODIFIED PER IIN-D205-708
D3284-025 TRIPOD ASSY	204-060-157-001 MODIFIED PER IIN-D205-708
D3284-031 TUBE ASSY	205-060-107-001 MODIFIED PER IIN-D205-708
D3284-033 BIPOD ASSY	205-060-106-001 MODIFIED PER IIN-D205-708
D3284-035 TRIPOD ASSY	205-060-105-001 MODIFIED PER IIN-D205-708



NOTE:

FOR FUTURE PROCUREMENT, THE PURCHASE ORDER MUST SPECIFY THAT THE MATERIAL USED TO MANUFACTURE THE D3284-001/-003/-005/-007 PARTS MUST COMPLY WITH THE FOLLOWING SPECIFICATIONS:

AISI 4130 ROUND BAR PER AMS 6348/MIL-S-6758 WITH
 MIN Ft_u = 90 Ksi
 MIN Ft_y = 70 Ksi

EACH INDIVIDUAL ITEM TESTED BEFORE USE OR PROVEN TO EQUAL OR EXCEED THE ABOVE.

CL 10/7/15

W10.60587

RELEASED

2010-03-25

B	ADD NOTE	RF	09.07.14
A	NEW ISSUE	KJ	04.05.06
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. B	
MFG. APPR.	<i>[Signature]</i>	D3284 SHEET 1 OF 1	
APPROVED	<i>[Signature]</i>	TITLE SCALE	
DE APPR.	<i>[Signature]</i>	ADJUSTABLE ENGINE MOUNT NTS	
DATE	09.07.14		
COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



INVOICE

10 Avenue
Reg. MB R2X 2V2
Tel: 204-772-9922
Fax: 204-772-7566

CUSTOMER NO. 1030019
INVOICE 12142
INVOICE DATE 30-08-2010

BILL TO:
Dart Aerospace Ltd
1270 Aberdeen Street

SHIP TO:
Dart Aerospace Ltd.
1270 Aberdeen Street

Hawkesbury, ON K6A 1K7
Canada

Hawkesbury, ON K6A 1K7
Canada

Attention: Accounts Payable

SHIP DATE	SHIP VIA	TERMS
10-08-2010	FEDEX ACCT# 2351 4353 4	Net 30 Days
P.O. NUMBER	ORDER DATE	OUR ORDER NUMBER
PO12260	27-08-2010	23228

DESCRIPTION	S/N	SHIP QTY.	UOM	UNIT PRICE	EXT. PRICE
5. EEEVE	<u>10-3000</u>	12	EA	117.00	1,404.00
3 STUD	<u>08-2515</u>	4	EA	84.00	336.00
4 STUD	<u>08-1927</u>	8	EA	84.00	672.00
10	<u>10-2599</u>	12	EA	96.00	1,152.00
17 (7500-16 UNJF-3B)	07-2750	12	EA	11.54	138.48
17 STEEL (7500-16 UNJF-3B-LH) LH THREAD	08-1060	12	EA	11.54	138.48

5 CURRENCY

SHIP VIA: FEDEX ACCT# 151793240

ORDERED BY: CHANTAL LAVOIE @ 613-632-9577

8608/31

Net Amount: 3,840.96
H.S.T. (ONT) 13% 499.32

G.S.T. # 89515 7576 RT0001

USD Total Due\$ 4,340.28

CERTIFICATE OF CONFORMITY

Form Tracking No.23228-1

Work Order/Contract/Invoice
PO/ 12260

Cage Code: MFR L0555

Item	Description	Part No.	Quantity	Serial/Batch	Status
1	Sleeve	B80702-1	12	10-3000	manufactured
2	Stud	B80703-1	4	08-2515	manufactured
3	Stud	B80704-1	8	08-1927	manufactured
4	Stud	B80705-1	12	10-2599	manufactured

8/10/08/131

Remarks:

THESE ITEMS CONFORM TO APPROVED DESIGN DATA B80702 (REV. A), B80703-1 (REV. A), B80704-1 (REV. A) AND B80705-1 (REV. B), AS APPLICABLE.

New-Unused Parts/Material Certification

The items described above have been manufactured using standards employed by a TCCA approved manufacturer in accordance with CAR 561 and a AS9100 Quality Assurance System.

Signature

Name R. D. WILLIAMSON

Date (dd mmm yyyy)
27 AUG 10

Used, Repaired or Overhauled Parts Certification

The items described above have been maintained using standards employed by a TCCA approved maintenance organization in accordance with CAR 573 and a AS9100 Quality Assurance System.

Signature

Name

Date (dd mmm yyyy)

User/Installer Responsibilities: This certificate does not constitute authority to install the item(s) described above on an in-service type certified aircraft.

ACS-NAI Ltd.

25 Dunlop Avenue
R2X 2V2 Winnipeg
Canada
Tel : 204-772-9922
Fax : 204-772-7568

Delivery No. : 1194
Delivery Date : 08/27/2010
SO No. : 23228
Your Reference : PO: PO12260
Delivery Method : FEDEX ACCT# 2351 4353 4
Payment Condition : Net 30 Days

Delivery to: Dart Aerospace Ltd.

Attention: Chantal Lavoie
1270 Aberdeen Street

Hawkesbury K6A 1K7
Canada

Item	Description Batch Number	Total Ordered	Unit	Qty Delivered	Delivery Date
B80702-1	SLEEVE 10-3000	✓ 12	EA	12	08/30/2010
B80703-1	7/8 STUD 08-2515	✓ 4	EA	4	08/30/2010
B80704-1	3/4 STUD 08-1927	✓ 8	EA	8	08/30/2010
B80705-1	STUD 10-2599	✓ 12	EA	12	08/30/2010
NAS509-12	NUT (.7500-16 UNJF-3B) 07-2750	✓ 12	EA	12	08/30/2010
NAS509-L12	NUT STEEL (.7500-16 UNJF-3B-LH) LH THREAD 08-1060	12	EA	12	08/30/2010
US CURRENCY					
SHIP VIA: FEDEX ACCT# 151793240					
ORDERED BY: CHANTAL LAVOIE @ 613-632-9577					

Packages: 0

Gross Weight: 0.00

Net Weight:

Ordered by: Dart Aerospace Ltd.

Attention: Chantal Lavoie
1270 Aberdeen Street

Hawkesbury K6A 1K7
Canada

Invoice to: Dart Aerospace Ltd.

Attention: Accounts
1270 Aberdeen Street

Hawkesbury K6A 1K7
Canada

0.00

Remarks**Certification Statement**

I hereby certify that the aircraft part(s) described hereon were acquired from a source of supply that is consistent with the conditions under which TCCA distributor approval AMO88-97 has been granted.

Signatory

Date:

27 Aug 2010